

Work Order ID 53163

October 23, 2009 1:29:53 PM



Page 1

Item ID: D3144-105

Accept



Setup Start



Revision ID: C

Stop



Item Name: Doubler

Start Date: 10/30/09 Start Qty: 4.00



Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3144	Rev C

100



PURCHASING

Waterjet

Memo

0.00

B 9-11-0

FLOW CNC Waterjet

1-Cut as per Dwg D3144-105

Dwg Rev:

Prog Rev:

2-Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

Quality Control

B 9-11-0

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

m 09 11 10 4

130



Small Fab

Small Fab

0.00

AB 9-11-10

Small Fab

Memo

0.00

Small Fab

Deburr

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Hand Finishing

Memo

0.00

09/11/11

(Y4) Ø

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Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

150



Powdercoat

Powder Coating

Operation
Description

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

M109091

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

BK 09-11-11

(XL) 9

(4)

170



Packaging

Packaging

Identify as per dwg & Stock Location: IAN

0.00

Memo

0.00

9/10/11 (4) SP

Work Order ID 53163

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Page 4

Item ID: D3144-105

Accept



Setup Start



Revision ID: C

Stop



Item Name: Doubler

Start Date: 10/30/09 Start Qty: 4.00



Cust Item ID:

Required Date: 10/30/09 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo :

0.00

09/11/12 JG

MF
09-11-11

Picklist Print

October 23, 2009 1:29:53 PM

Page 1

Work Order ID: 53163



Parent Item: D3144-105RevC



Parent Item Name: Doubler

Start Date: 10/30/09

Required Date: 10/30/09

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.032		Purchased		No		100	sf	59.3122	0.8632			IS 9-11-6

2024-T3 .032 sheet

Warehouse

Location

Main Warehouse

MAT	59.31223158	
102942	1.5	
105555	4.0684	
106272	5.3	
108595	1.2	
109240	7.02	
110778	18.8996316	110778
111699	18.3242	
18147	3	

DART AEROSPACE LTD	Work Order:	53163
Description: Doubled	Part Number:	D3144-105
Inspection Dwg: D3144-105 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

x First Article **Prototype**

Measured by:	<u>HR</u>	Audited by:	<u>MH</u>	Prototype Approval:	N/A
Date:	9-11-10	Date:	09.11.10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

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RETURN TO

ENGINEER P.D.G.

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK CENTER

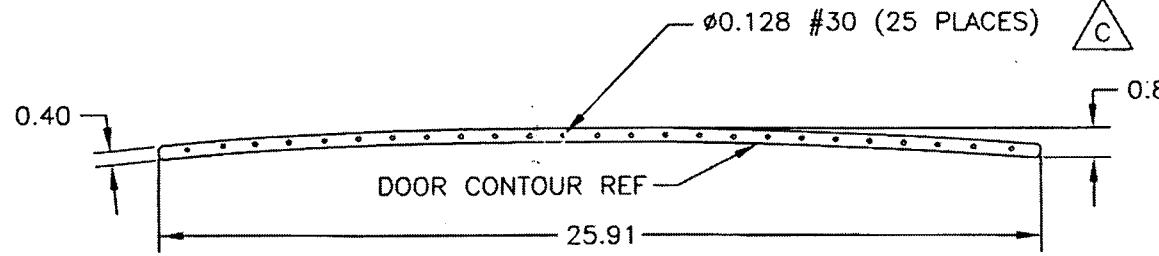
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DART

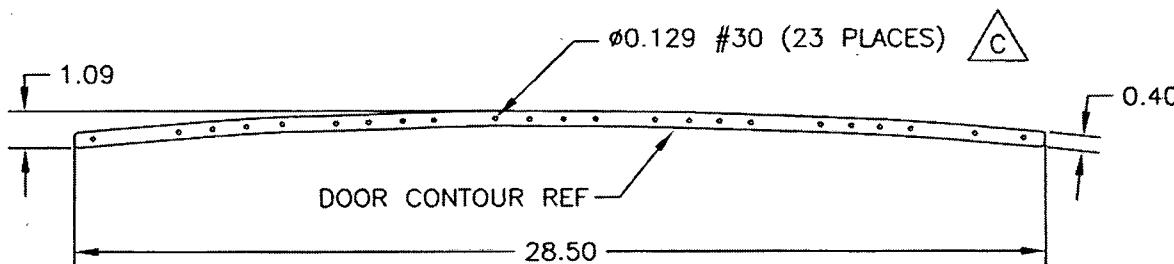
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05.11.14 -
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3144	REV. C	SHEET 1 OF 9
DATE 05.10.19	TITLE DOUBLER			SCALE 1:5
A	02.04.22	NEW ISSUE		
B	04.09.17	ADDED D3144-105/-107/-109/-111/-115/-121/-123; MODIFY D3144-1		
C	05.10.19	ADD D3144-15; Ø0.129 WAS Ø0.098		



D3144-1 DOUBLER (FOR D412-694-03)
REPLACES PREMIER P/N B30-23000-191



D3144-3 DOUBLER (FOR D412-694-01)
REPLACES PREMIER P/N B30-23000-193

D3144-1/-3 NOTES:

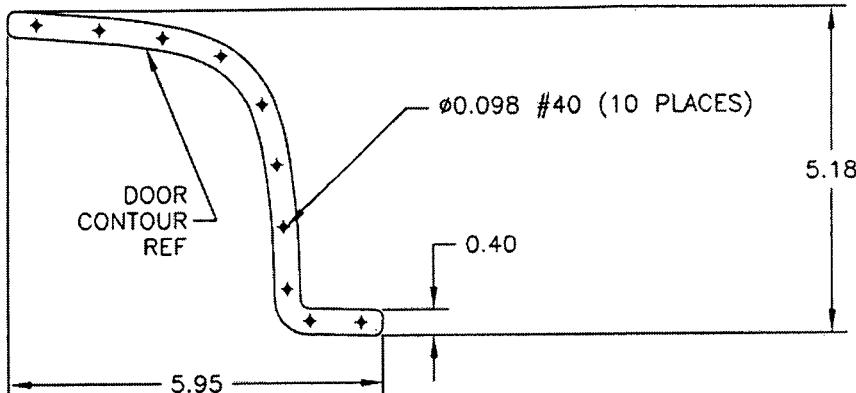
- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C1.DWG"

53163

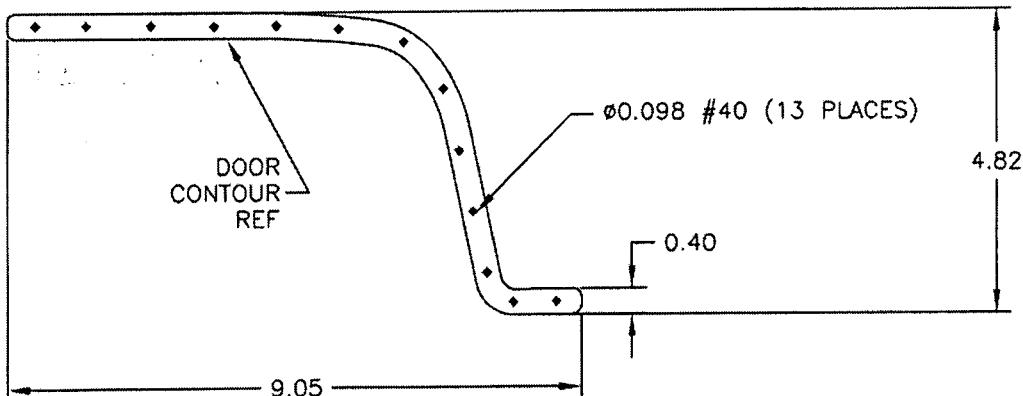
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DART

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DATE 05.10.19		TITLE DOUBLER	SCALE NTS



D3144-5 DOUBLER
REPLACES PREMIER P/N B30-23000-195



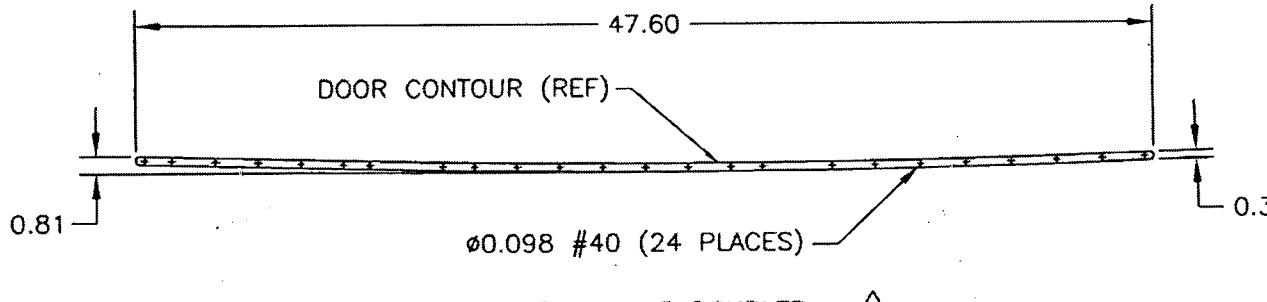
D3144-7 DOUBLER
REPLACES PREMIER P/N B30-23000-197

D3144-5/-7 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C2.DWG"

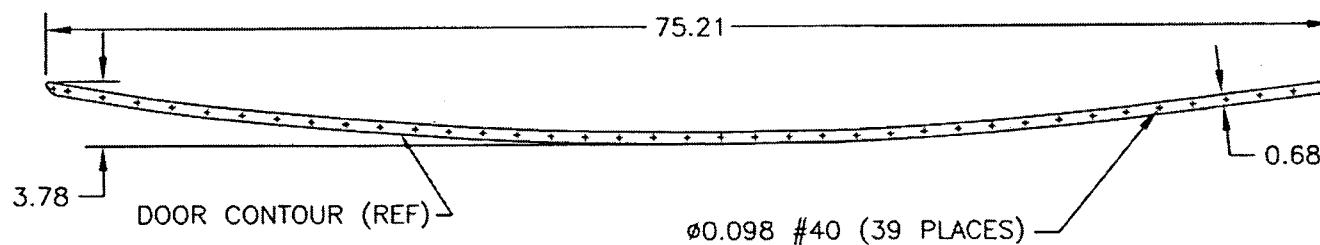
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05.11.14



D3144-15 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"



D3144-13 NOTES:

REPLACES PREMIER P/N B30-23000-211

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.020 THICK (REF DART SPEC M2024T3S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C4.DWG"

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S3144-13

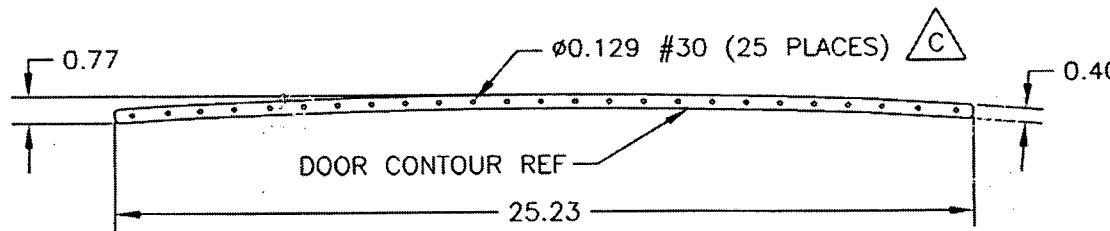
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DATE 05.10.19		REV. C SHEET 4 OF 9 SCALE NTS

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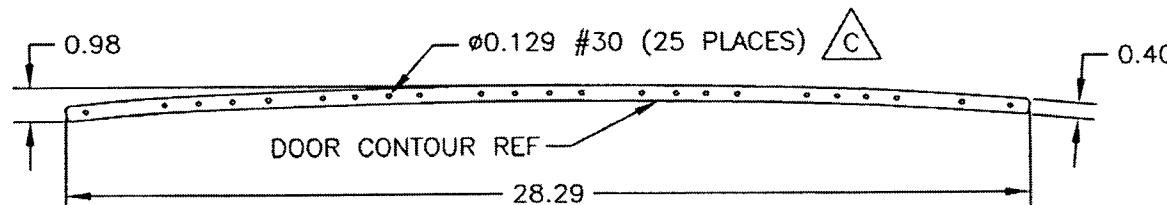
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D3144-119 DOUBLER (FOR D412-694-04)



D3144-123 DOUBLER (D412-694-02)

D3144-119/-123 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C5.DWG"

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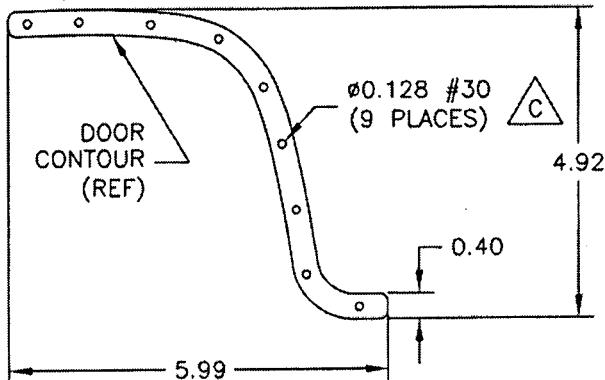
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DATE 05.10.19	TITLE DOUBLER	SHEET 5 OF 9	SCALE NTS	

53163

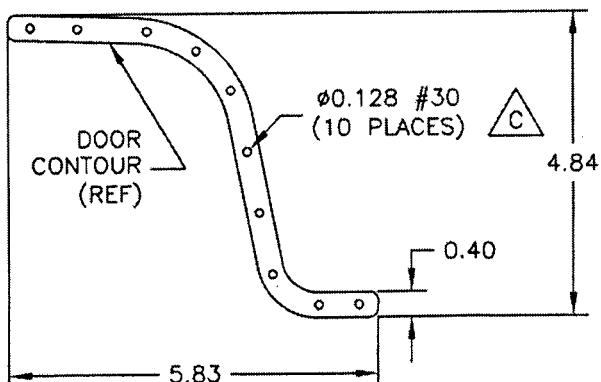
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DATE 05.10.19		TITLE DOUBLER	SCALE NTS



D3144-105 DOUBLER (FOR D412-694-03)



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05.11.14 *[initials]*

D3144-117 DOUBLER (FOR D412-694-04)

D3144-105/-117 NOTES:

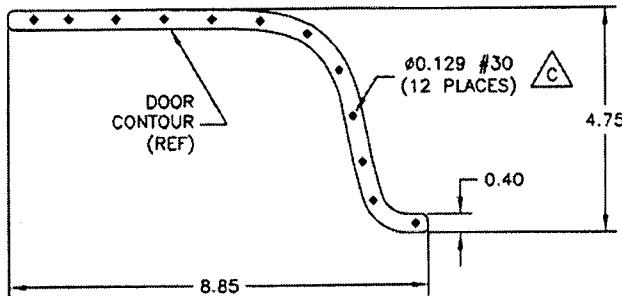
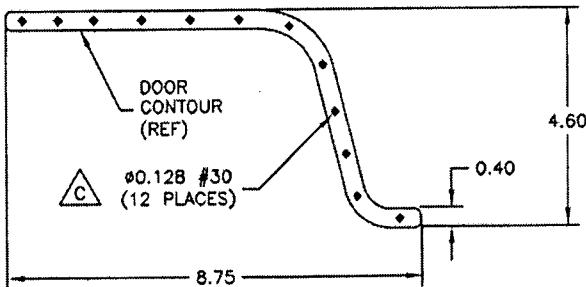
- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C6.DWG"

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DATE 05.10.19	TITLE DOUBLER	SCALE NTS	

**D3144-107 DOUBLER (FOR D412-694-03)****D3144-121 DOUBLER (FOR D412-694-04)**

RELEASED

05-11-14 *[initials]***D3144-107/-121 NOTES:**

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING FILE "D3144-C7.DWG"

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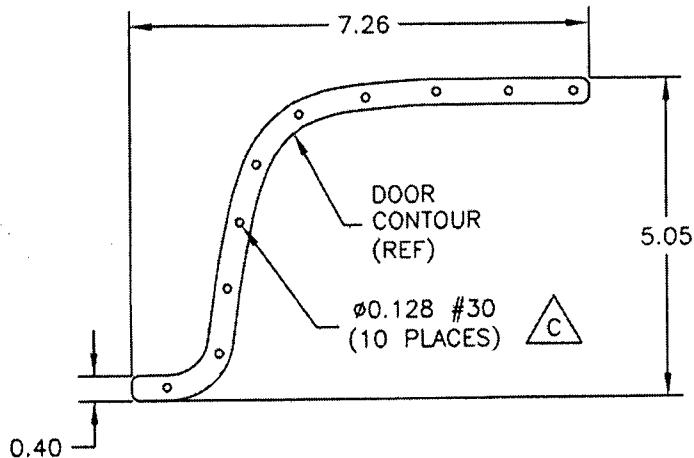
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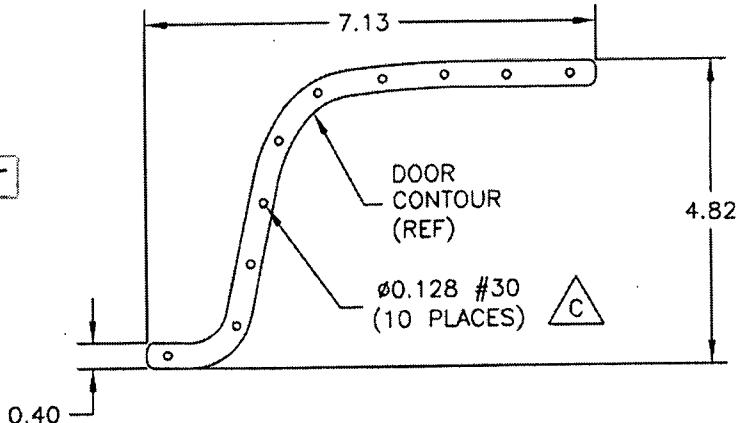
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DATE 05.10.19	TITLE DOUBLER	REV. C SHEET 8 OF 9 SCALE NTS



D3144-109 DOUBLER (FOR D412-694-01)

RELEASED

05.11.14 *[initials]*



D3144-115 DOUBLER (FOR D412-694-02)

D3144-109/-115 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C8.DWG"

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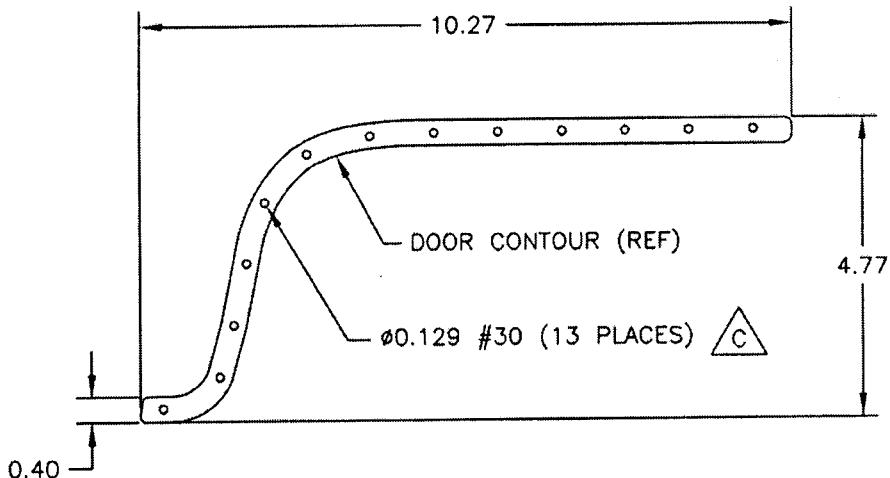
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3144	REV. C SHEET 9 OF 9
DATE 05.10.19	TITLE DOUBLER	SCALE NTS	

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05.11.14 *H*



D3144-111 DOUBLER (FOR D412-694-01/-02)

D3144-111 NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.032 THICK (REF DART SPEC M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MACHINE PER DRAWING "D3144-C9.DWG"

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